

Date Thursday, 16/08/2007 11:31:55 AM
User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI ACCESS HANDLE WELDMENT ASSY, LH
Job Number : 34015
Estimate Number : 10947
P.C. Number : N/A Part Number : D2480012
This Issue : 16/08/2007 S.O. No. : NA Drawing Number : D2480 REV A1
Prsht Rev. : NC Project Number : N/A
First Issue : MA Type : LARGE FAB ASSY Drawing Revision : A1
Previous Run : N/A Material : N/A
Written By : Due Date : 03/09/2007 Qty: 5 Um: Each
Checked & Approved By :
Comment : Est. C1 03.01.09 Added Powder Coat

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2478 Lower Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B34030

FC

(XS)

2.0 D2479 Upper Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B34031

FC

(XS)

3.0 D2481 Lower Mount Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B23503



FC

(Y10)

4.0 D2482 Upper Mount Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B23504

FC

(XS)

07/10/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R Date: 04/10/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:31:55 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASSY, LH

Job Number: 34015

Part Number: D2480012

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

FC 07/10/18 (5)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-19 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SC 07/10/19 (X) (5) (H)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M105068

m.k 07/10/20 (5) (H)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/10/22 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/11/22 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 07/10/20 (5)

Job Completion



W.A. 10.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

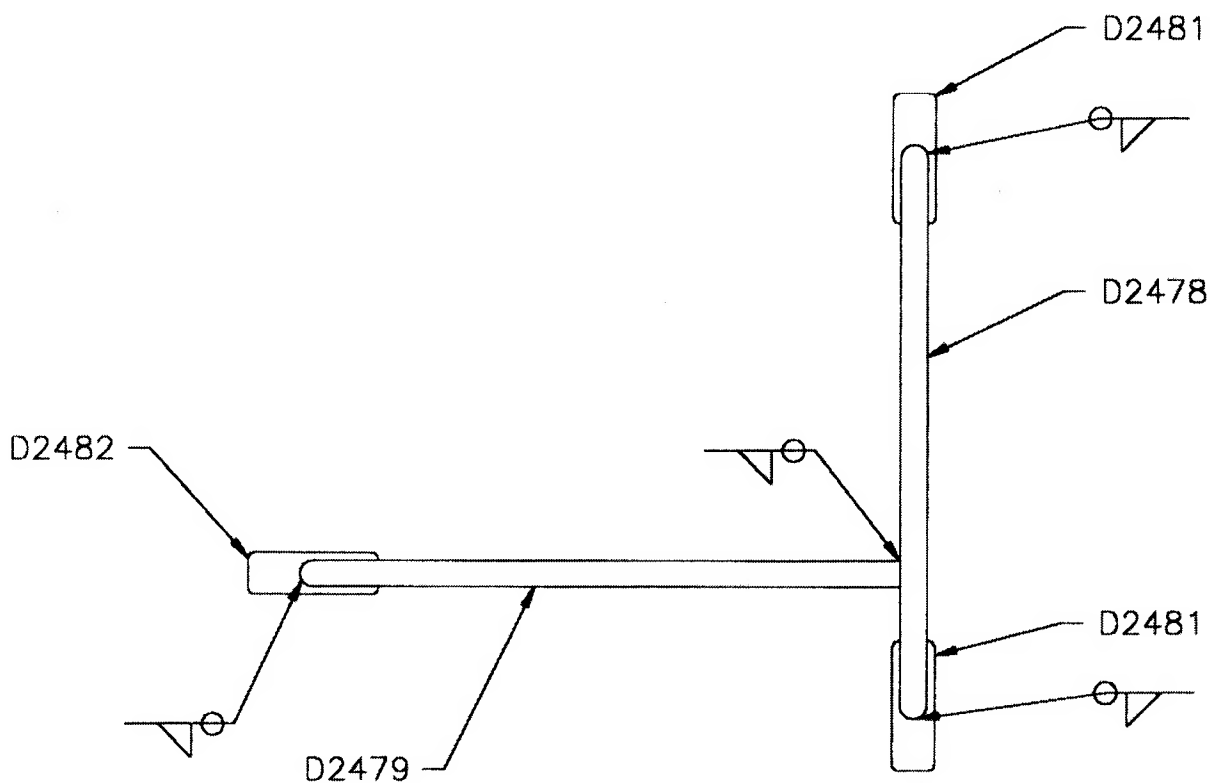
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED	APPROVED	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
AI	05.06.23	ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

W/O
3/15

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005